

Step 27/03 6

Dart Aerospace Ltd.

Date: Tuesday, 3/18/2008 3:55:11 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE
Job Number : 38086	
Estimate Number : 12687	
P.O. Number :	Part Number : D35711
This Issue : 3/18/2008 S.O. No. :	Drawing Number : D3571 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32829	Material :
Written By :	Due Date : 3/28/2008 Qty: 15 Um: Each
Checked & Approved By : <u>JL 080318</u>	
Comment : Est Rev: A New Issue 07-02-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
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Comment: Qty.: 0.2531 f(s)/Unit Total : 3.7958 f(s)
6061-T6 Bar .75" X 1.5"
Batch: M104326

J.L 08/03/24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank 2.90 " long

J.L 08/03/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA675Rev: A & Dwg D3571 Rev: A

2-Deburr per dwg D3571

J.L 9M/Y.A 08/03/25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 9M/Y.A 08/03/25

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8F 08/03/26 (15)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:55:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 38086

Part Number: D35711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



15

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-03-26

7.0

POWDER COATING

POWDER COATING



15

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR 08-03-27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



15

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/03/27

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 57247

08/03/27

15

10.0

QC21

FINAL INSPECTION/W/O RELEASE



15

Comment: FINAL INSPECTION/W/O RELEASE

17 08/03/27

Job Completion



mf 08-03-27
h

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38086
Description: Guide		Part Number:	D3571-1
Inspection Dwg: D3571 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	✓			
Ø1.00 Depth 100	+/-0.010	.998X.101	✓			
2.75	+/-0.030	2.752	✓			
1.38	+/-0.030	1.38	✓			
1.25	+/-0.030	1.251	✓			
0.63	+/-0.010	.629	✓			
0.031 chamfer	+/-0.010	.029	✓			
Ø0.500	+0.006/-0.001	.501	✓			
Ø0.201	+0.005/-0.001	.203	✓			
R0.25	+/-0.030	0.25	✓			
0.260	+0.000/-0.010	.259	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	.386X100°	✓			
0.125	+/-0.010	.126	✓			
2.250	+/-0.010	2.249	✓			
0.250	+/-0.010	.250	✓			
0.188	+/-0.010	.188	✓			
0.063 chamfer	+/-0.010	.065	✓			

Measured by:	J.L
Date:	08/03/24

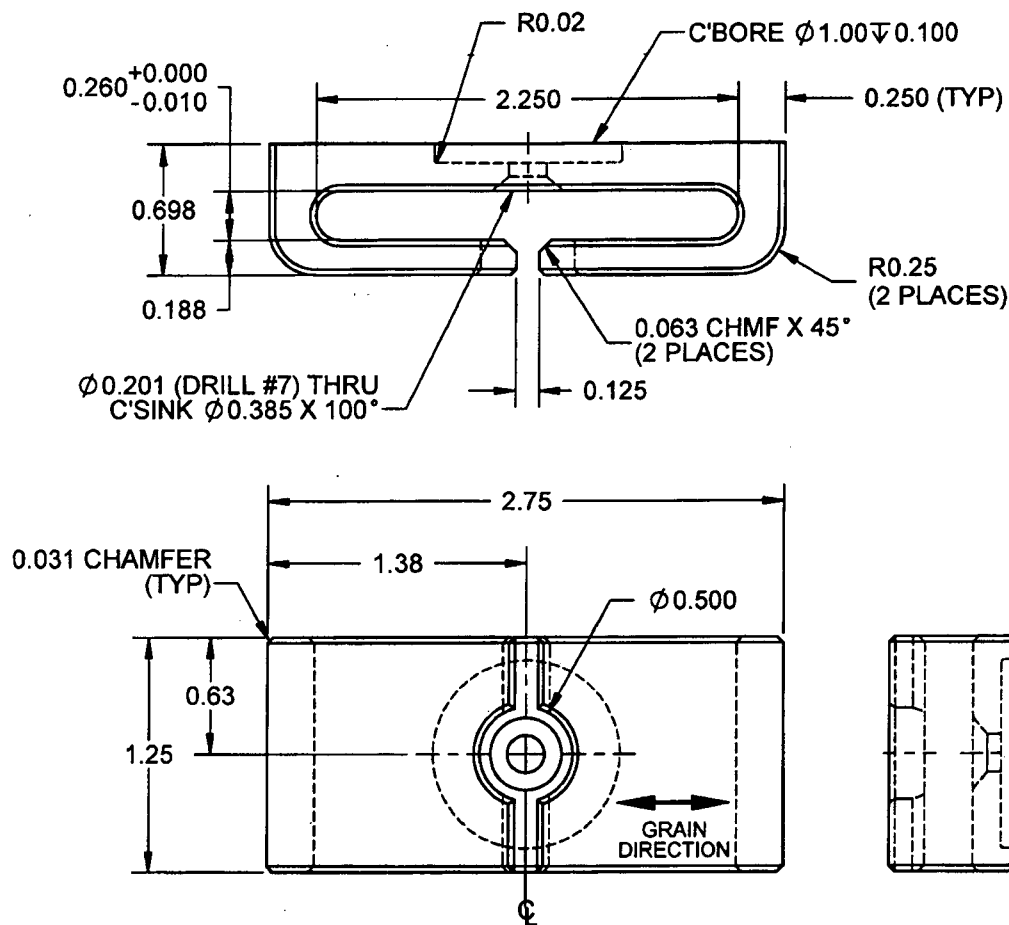
Audited by:	SI
Date:	08/03/24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE		SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]***D3571-1 GUIDE**

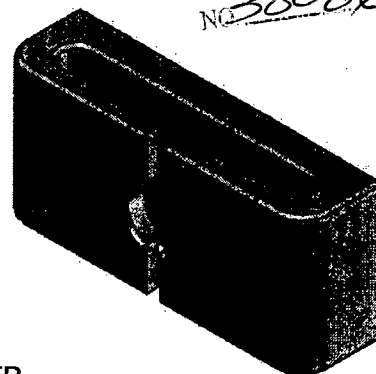
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NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

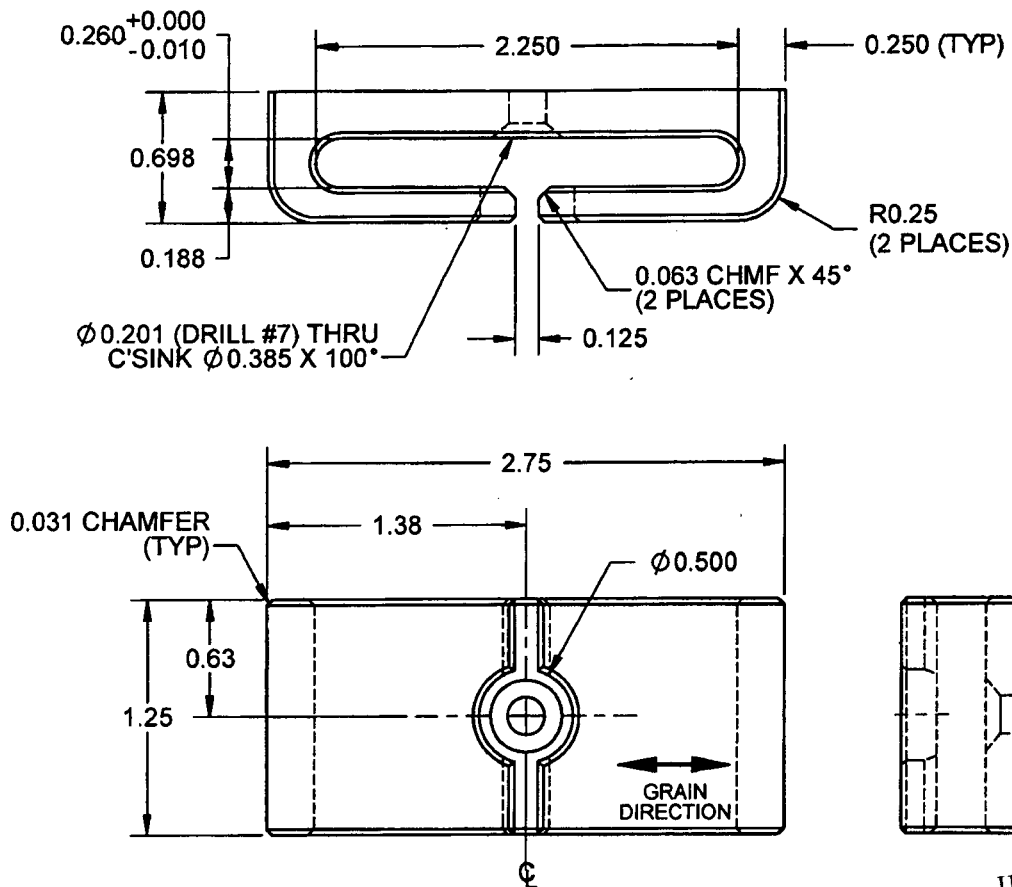
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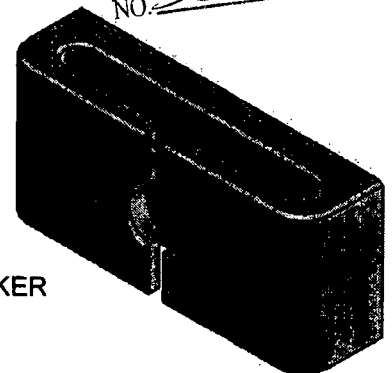
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CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29	TITLE GUIDE		SCALE 1:1

RELEASED07.01.12 *PH***D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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